

Work Order ID 64463

Monday, December 06, 2010 10:18:36 AM



Page 1

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *10-12-6*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2857	Rev B								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 4.425"								

SL 10/12/08

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA940 FOLIO REV: <i>4A</i> DWG REV: <i>C</i> 2-Deburr any rough edges								

SL 10/12/13

(20)

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

SL 10/12/13

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Hinge Bracket

Start Date: 12/6/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

L.A 10/12/13

20

Ø

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

⇒ M 10/12/13

20

G

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 10-12-14.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Monday, December 06, 2010 10:18:36 AM



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Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M 115951

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:45

OVEN TEMPERATURE:

3:20 FINISH TIME:

8:15

20

BL 10-12-14

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 10/12/14

20 0

180

Identify as per dwg & Stock Location: 25

0.00



Packaging

Memo

0.00

Packaging

10/12/14 (202)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64463

Monday, December 06, 2010 10:18:36 AM



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Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/14 JF

u 10.18.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:18:40 AM

Page 1

Work Order ID: 64463



Parent Item: D2857-2



Parent Item Name: Hinge Bracket

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ C 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐
IPP ☐ D 06.03.30 ☐ Added level 8 ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B2.000X01.25
0

Purchased

No

100

f

27.4555

0.37

7.789474



SL 10/12/08

6061-T6 Bar 2.00 x 1.25

Location

Loc Qty

Loc Code

MAT

27.4555

114507

15.4555

114899

12

7.8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64463
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: B	Page 1 of 1	

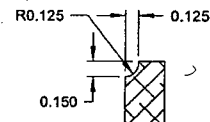
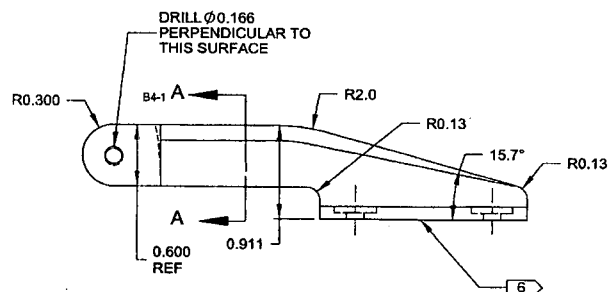
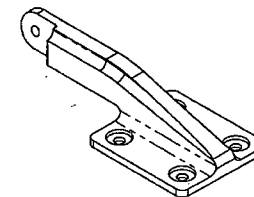
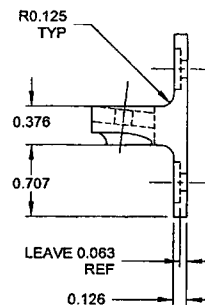
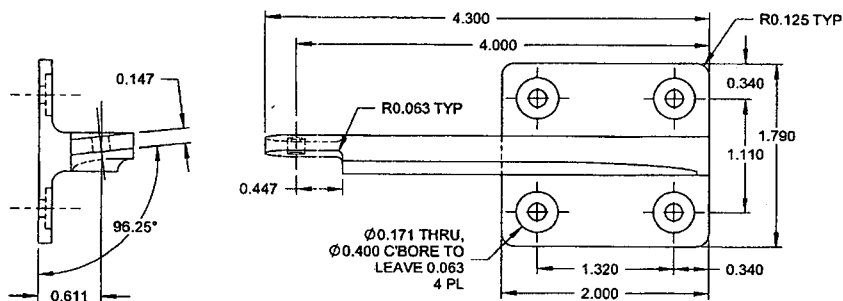
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	✓		vern. cal-3	
4.000	+/-0.010	4.001	✓		"	
0.340	+/-0.010	0.340	✓		"	
1.110	+/-0.005	1.110	✓		"	
1.790	+/-0.010	1.791	✓		"	
1.320	+/-0.005	1.320	✓		"	
2.000	+/-0.010	2.001	✓		"	
0.340	+/-0.010					
0.447	+/-0.010	0.448	✓		H-G	
Ø0.171	+0.005/-0.000	0.173	✓		"	
0.147	+/-0.010	0.143	✓		"	
0.376	+/-0.010	0.378	✓		"	
0.126	+/-0.010	0.125	✓		"	
0.063	+/-0.010	0.062	✓		"	
Ø0.166	+0.005/-0.000	0.167	✓			
0.911	+/-0.010	0.905	✓		H-G	
0.600	+/-0.010	0.591	✓		"	
0.125	+/-0.010	0.127	✓		"	
0.150	+/-0.010	0.149	✓		"	

Measured by:	SL	Audited by:	B.A	Prototype Approval:	N/A
Date:	10/12/09	Date:	10/12/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	



B7-1 SECTION A-A

D2857-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG, IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	DP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.13		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
DRAWING NO.	D2857	SHEET 1 OF 2
TITLE	HINGE BRACKET	SCALE
		NTS

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